

Work Order ID 87040

July-10-12 11:56:50 AM

87040

Page 1

Item ID: D119-646-213

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Skidtube w/ Training Wearplates, LH

Stop

NS2

Start Date: 7/10/12 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 8/17/12 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
IIN-D119-646	B

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-213
CHG 001

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
16
S-6
12/06/13

(Y1)

12/07/10 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87040

87040

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July-10-12 11:56:50 AM

Item ID:	D119-646-213	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:						Stop	*NS2*
Item Name:	Float Skidtube w/ Training Wearplates, LH						
Start Date:	7/10/12	Start Qty:	1.00	*1*	Cust Item ID:		
Required Date:	8/17/12	Req'd Qty:	1.00	*1*	Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130 Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-642-213 Location: <u>73</u> PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC	Memo	0.00							
Quality Control									

12/8/12

MLJ 12/08/12

MF
12-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							/

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

AN3G50A

Bolt

Purchased No 110 Each 50.0000

8

8

JB

AN4G6A

Bolt

Purchased No 110 Each 423.0000

13

18

JB

MS21250-05-006

BOLT

Purchased No 110 Each 20.0000

8

8

JB

AN960C10L

washer

NAS1149C0332R Purchased No 110 Each 21.0000

17

17

9X M122063

JB

87M121509

AN960C416L

WASHER

AN960C516L

WASHER

Purchased No 110 Each 0.0000

30

30

24X 117271

JB

6X 121255

JB

8

8

19436

JB

12/10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Nut

Purchased No

110 Each 1,094.0000

8

8

✓ JB

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	1022	
118077	2	
118614	12	
118686	30	
119758	20	
121255	101	121255
121708	857	

MS21043-4

Nut

Purchased No

110 Each 1,779.0000

13

13

✓ JB

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	739	
119546	4	
121162	295	
121652	440	
ST318	1000	
122141	1000	

D2512

Set Screw

Manufactured No

110 Each 621.0000

12

12

✓ JB 12/07/10

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST017	571	
81871	71	
83559	250	
84433	250	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3672-7
Phenolic Washer

Manufactured	No	110	Each	712.0000
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24

24

JB

Location	Loc Qty	Loc Code
ST060	712	
73488	16	
76279	196	76279
81872	500	

D3672-3
Phenolic Washer

Manufactured	No	110	Each	1,311.0000
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30

30

JB

Location	Loc Qty	Loc Code
ST060	1311	
84361	311	84361
84432	500	
86517	500	

D3407-041
Tow Ring

Manufactured	No	110	Each	2.0000
--------------	----	-----	------	--------

0

1

JB

D3417-5
Washer

Location	Loc Qty	Loc Code
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0

1

JB

ST463	2	82068
82068	2	

110	Each	133.0000
-----	------	----------

0

1

JB

12/07/10

Location	Loc Qty	Loc Code
ST042	133	
78842	4	
83318	48	
84943	40	
85466	41	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 11:56:50 AM

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Work Order ID: 87040

Parent Item: D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 7/10/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3456-4
Washer

Manufactured No 110 Each 215.0000

0 1 ✓ JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	7	
25701	7	
ST044	208	
80252	1	
81876	15	81876
83584	92	
85223	100	

D3417-7
Washer

Manufactured No 110 Each 36.0000

0 1 ✓ JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST042	36	
51645	18	51645
75054	18	

AN960JD416
Washer

NAS1149D0463J Purchased No 110 Each 29.0000

6 121912 6 ✓ JB 12/07/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	29	
116289	8	
119097	21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

4.3 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
1	1					X							D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
		1	1				X						D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
								X					D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
									X				D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
										X			D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
1	1	1	1	/ 1	1						X		D119-646-311	GROUND HANDLING KIT
1							1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
24									1				D3846-1	GASKET
25									1				D3846-11	GASKET
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44										1			D3849-047	FWD TRAINING WEARPLATE ASSY
45										1			D3849-045	AFT TRAINING WEARPLATE ASSY
46										1			D3846-1	GASKET
47										1			D3846-11	GASKET
48										1			D3847-1	WEARPAD
49										1			D3847-11	WEARPAD
51										16			D3904-1	WASHER
52										8			AN3C46A	BOLT
53										8			MS21043-3	NUT
54										10			AN3C5A	BOLT
55										10			AN960C10L	WASHER (OR NAS1149C0332R)
60	2	2	2	/ 2	2								D3883-1	SADDLE, OUTSIDE, LH
61	2	2	2	/ 2	2								D3883-2	SADDLE, OUTSIDE, RH
62	2	2	2	/ 2	2								D3884-1	SADDLE, INSIDE, LH
63	2	2	2	/ 2	2								D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16								D2652	BUSHING
65	8	8	8	8	8								AN3C50A	BOLT
66	12	12	12	12	12								AN4C6A	BOLT
67	8	8	8	8	8								MS21250-05006	BOLT
68	8	8	8	8	8								AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24								AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8								AN960CS16L	WASHER (OR NAS1149C0532R)

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Revision: B
 Date: 09.06.29

Item	Qty -013	Qty -014	Qty -113	Qty -114	(Qty) -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TQW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
100	3	3	3	3									AN3C45A	BOLT
101					(3)	(3)							AN3C50A	BOLT
102	3	3	3	3									AN3C45A	BOLT
103					(3)	(3)							AN3C46A	BOLT
104					(9)	(9)							D3904-1	WASHER
105	6	6	6	6	6	6							AN4C6A	BOLT
106	6	6	6	6	6	6							D3672-3	WASHER
107	6	6	6	6	6	6							AN960C416L	WASHER (OR NAS1149C0432R)
108	6	6	6	6	6	6							AN960JD416	WASHER (OR NAS1149C0463J)
109	12	12	12	12	(3)	(3)							AN960C10L	WASHER (OR NAS1149C0332R)
110	6	6	6	6	(6)	(6)							MS21043-3	NUT

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NEED TO BE INCLUDED WITH KIT.
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.